

**Work Order ID 59626**

Page 1

Wednesday, June 09, 2010 8:42:15 AM

Item ID: D3791-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 6/9/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: HDate: 10-6-09 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3791	Rev A

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

B10-6-22

FLOW CNC Waterjet

304 .063

1-Cut as per Dwg D3791

Dwg Rev: AProg Rev: A

2-Deburr if necessary

1

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

B10-6-22

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 59626**

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Item ID: D3791-1

Revision ID:

Item Name: Wearplate

Start Date: 6/9/2010 Start Qty: 12.00

Required Date: 6/24/2010 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

S106123

(12)

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

1-Deburr if necessary

S106123

(12)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Ensure Joggle as per dwg D3429.

S106123

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID 59626**

Wednesday, June 09, 2010 8:42:15 AM



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**Item ID:** D3791-1**Revision ID:****Item Name:** Wearplate**Start Date:** 6/9/2010 **Start Qty:** 12.00**Required Date:** 6/24/2010 **Req'd Qty:** 12.00**Reference:****Accept****Setup Start****Stop****Approvals:** Process Plan:

Date:

Tooling:

Date:

**Run**

QC:

Date:

SPC (Y/N):

Date:

**Stop****Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours****Tool ID****Tool #****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

150



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: M11464

S10/06/23

10-6-23

(X12)

160



QC10- Inspect visual per QSI004- ground welds

0.00

QC

Quality Control

S10/06/23

(HZ)

170



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

S10/06/23

(HZ)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 59626**

Wednesday, June 09, 2010 8:42:15 AM



Page 4

Item ID: D3791-1

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Revision ID:

Item Name: Wearplate

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Start Date: 6/9/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180



Grey Sandtex(Ref:4.3.5.6) per QSI005.4.3

M112588

0.00

12 Bk 10-6-28

Powdercoat

Powder Coating

Memo

0.00

190



QC3- Inspect Part Finish

0.00

11/10/08 12

QC

Quality Control

Memo

0.00

200



Identify as per dwg &amp; Stock Location FP17

0.00

My 10/06/29

Packaging

Packaging

Memo

0.00

12 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**Work Order ID 59626**

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Item ID: D3791-1

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Revision ID:

Item Name: Wearplate

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Stop



Start Date: 6/9/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

210



QC

Quality Control

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/29 JH

6/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, June 09, 2010 8:42:19 AM

Page 1

Work Order ID: 59626



Parent Item: D3791-1



Parent Item Name: Wearplate

Start Date: 6/9/2010

Required Date: 6/24/2010

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC  
IPP Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Otv	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	128.0000	0.2917	3.684632			

304/316 Sheet .063

(B10-6-22)

Location	Loc Qty	Loc Code
MAT	128	
111323	0	
114799	128	114799

(D)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59626
Description: Wearplate	Part Number:	D3791-1
Inspection Dwg: D3791	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-6-23	Date:	10/06/23	Date:	N/A

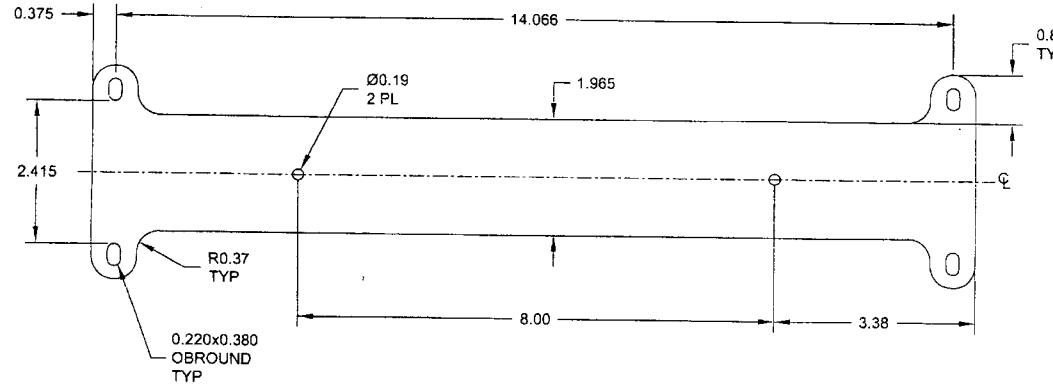
Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

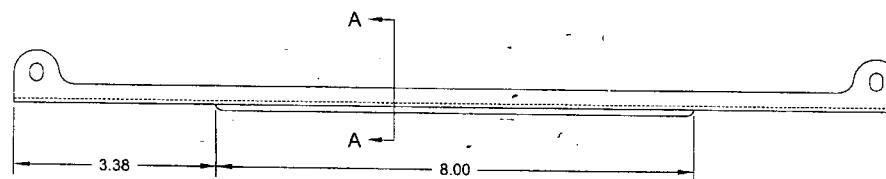
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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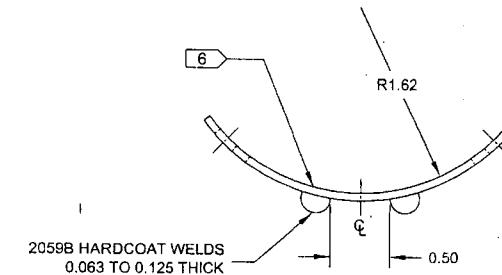
NOTE: Date & initial all entries



**D3791-1F FLAT PATTERN**



**D3791-1 WEARPLATE**  
(MAKE FROM D3791-1F)



**SECTION A-A**  
SCALE 2X

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 54626  
BS-0-6-09

*RELEASED*  
*04-05-21/10*

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

A	NEW ISSUE	PH	08.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	P4	DART AEROSPACE USA, INC	
DRAWN	P4	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3791	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	08.05.13	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED OR COPIED IN WHOLE OR IN PART, OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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